

Date: Monday, 6/25/2007 9:10:13 AM
User: Kim Johnston

Process Sheet

① b

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOUBLER
Job Number : 33116	
Estimate Number : 10709	
P.O. Number :	Part Number : D32101
This Issue : 6/25/2007 S.O. No. :	Drawing Number : D3210 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 32865	Material :
Written By :	Due Date : 7/10/2007 Qty: 20 Um: Each
Checked & Approved By : <u>Kim Johnston</u>	
Comment : Est Rev:A New Issue 05-11-17 JLM	
Est Rev:B Now On Waterjet 06-10-24 JLM	

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M2024T3S080 2024-T3 .080 sheet



Comment: Qty.: 2.6177 sf(s)/Unit Total : 52.3530 sf(s)
Material: 2024-T3 (QQ-A-250/4) 0.080" thick
(M2024T3S.080)Identify as D3210-1
Batch: M104921 1B07-08-05

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
1-Cut as per Dwg D3210
Dwg Rev: A
Prog Rev: A

1B07-08-05

20

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



1B 07-08-05

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

En 07/08/07

20

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr

Q.M 07.08.07

20

5.1 QCS

En 07/08/07

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 6/25/2007 9:10:13 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 33116

Part Number: D32101

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(20X)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-L

07/08/13

7.0

POWDER COATING

POWDER COATING



(20X)

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

BR / M-L 07/08/13

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7/8/14 SP (20)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

CP 07/08/14 (20)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.08.14

Job Completion



07/08/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

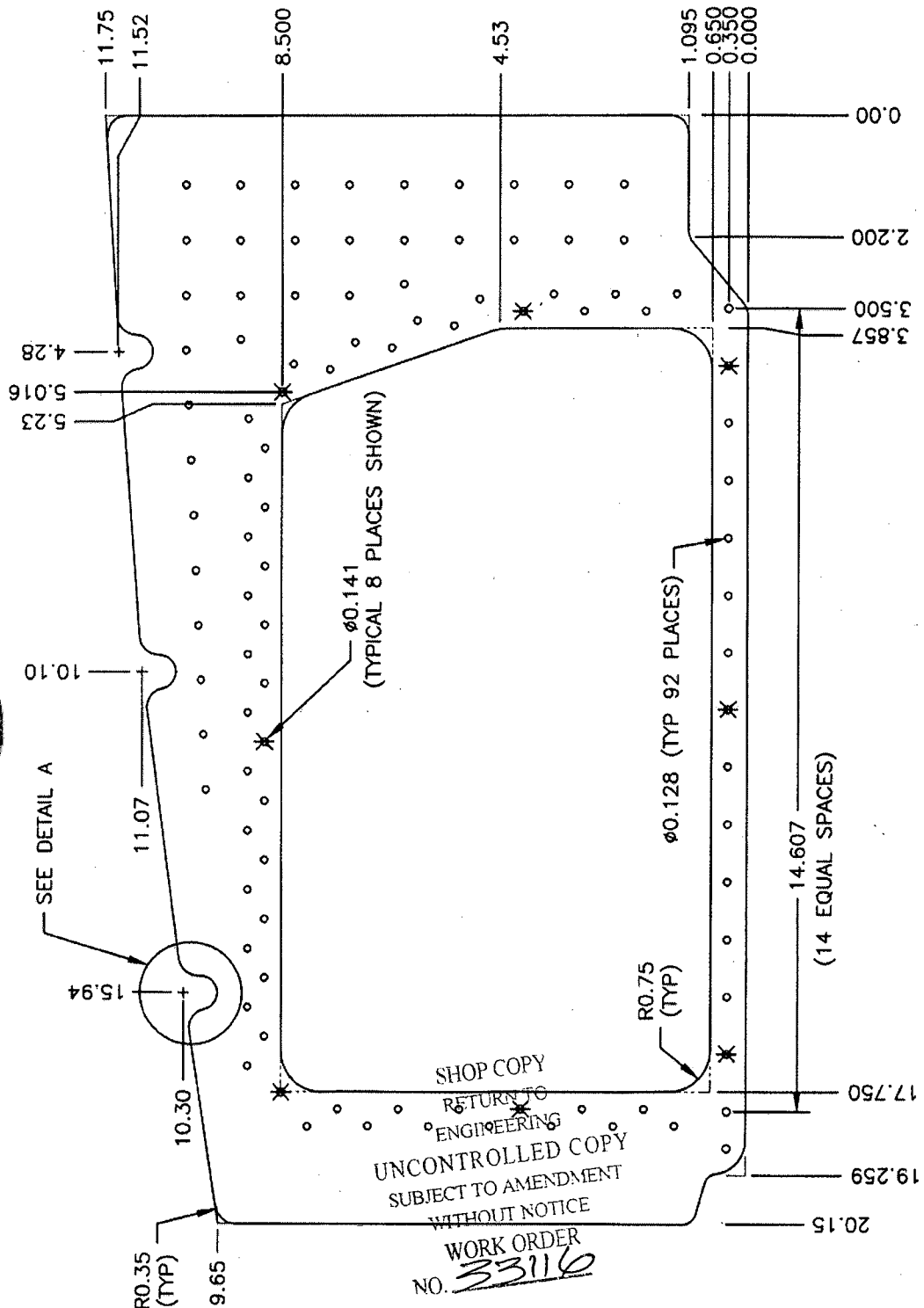
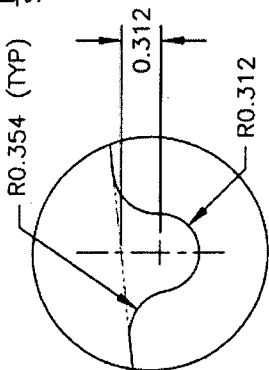


DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3210	REV. A SHEET 1 OF 1
DATE 03.09.03	TITLE DOUBLER	SCALE 1:3	
A	03.09.03	NEW ISSUE	

D3210-1 DOUBLER
MAKE PER DRAWING FILE "D3210-A1.DWG"
CHECK PER TEMPLATE D3210-1T1
DIMENSIONS SHOWN FOR REFERENCE ONLY
MATERIAL: 2024-T3 (00-A-250/4) SHEET 0.080 THICK
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT BLACK SANDEX (REF. 4.3.5.7) PER
DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
03.09.05

DETAIL A
SCALE 2:3



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 33116

Copyright © 2003 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.